

Date: Tuesday, 24/02/2009 8:31:01 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FOOT
Job Number	: 46046		
Estimate Number	: 11245		
P.O. Number	:	Part Number	: D34371
This Issue	: 24/02/2009 S.O. No. :	Drawing Number	: D3437 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 44787	Material	:
Written By	: <u>JLM 09.02.24</u>	Due Date	: 03/03/2009 Qty: 12 Um: Each
Checked & Approved By	:		
Comment	: Est. A 05.05.19 New issue KJ/JLM Est Rev:B Now on Doosan 08-09-11 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R1000	ROUND BAR 1.00"
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Comment: Qty.: 0.5424 f(s)/Unit Total : 6.5092 f(s)

ROUND BAR 1.00"

Material : 6061-T6 Round Bar Ø1.00" (QQ-A-225/8 or QQ-A-200/8)
 (M6061T6R1.000)

Identify for D3437-1

Batch: M104554 X 8 Dwg Rev. B

NO MATL IN COMPUTER

2.0	DOOSAN LATHE	DOOSAN LATHE
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Comment: Doosan Lathe

1- Turn as per Folio FA782 Rev: N/A & Dwg D3437 Rev: B

2-Tap hole as Dwg D3437

3-Deburr per dwg D3437

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J. A 09/03/19

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FOOT

Job Number: 46046

Part Number: D34371

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(XR)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

(MD) BR

09/03/19

6.0 POWDER COATING POWDER COATING



m110939

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Mask threaded hole

START TIME:

13:45

OVEN TEMPERATURE:

320°

FINISH TIME:

14:15

(MD) FL

09/03/23

(X12)

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



(12)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SS

09-03-23

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST500

SS 09/03/24

(X12)

9.0 QC21 FINAL INSPECTION/W/O RELEASE



09/03/24

Comment: FINAL INSPECTION/W/O RELEASE

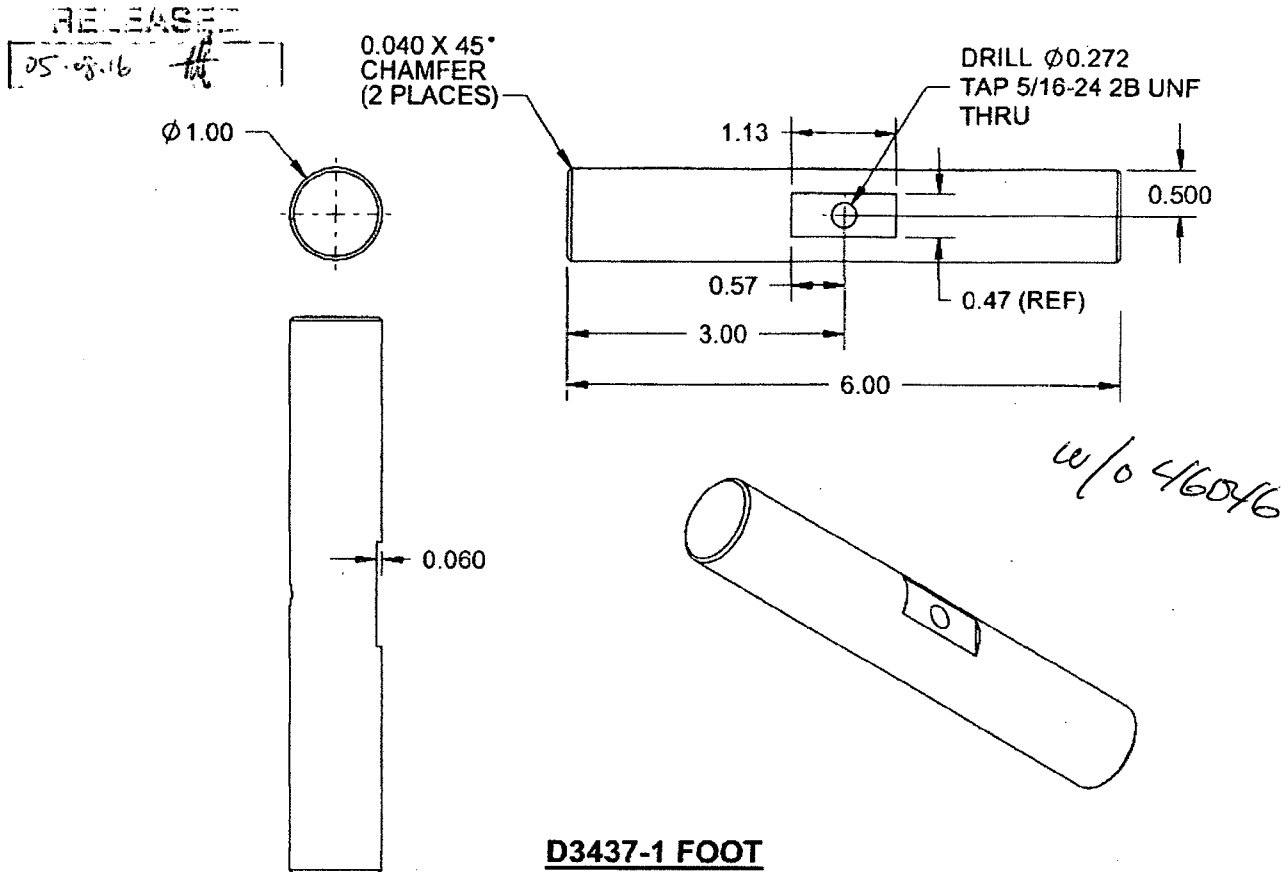
Job Completion



MF
09-03-24



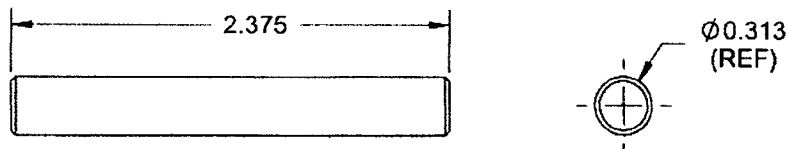
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3437	REV. B
DATE 05.08.11		TITLE AFT STRUT ASSEMBLY	SHEET 3 OF 4 SCALE 1:2



D3437-1 FOOT

D3437-1 FOOT:

- 1) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) ALUMINUM ROUND BAR
(REF. DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010



D3437-7 THREADED ROD

D3437-7 THREADED ROD:

- 1) POSSIBLE SUPPLIER: HASKINS-SPAENAU P/N 870-832 18-8 5/16-24 SS THREADED ROD
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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